

Date:
User:

Fnday, 9/7/2007 10:14:33 AM
Kim Johnston

Dart Aerospace Ltd.

Process Sheet

Splint W6
03 07/12/03

Customer : CU-DAR001 Dart Helicopters Services
Job Number : 34461 -2
Estimate Number : 12363
P.O. Number : *NA*
This Issue : 9/7/2007
Prsht Rev. : NC
First Issue : *NA*
Previous Run : 30775

Drawing Name : TAIL LIGHT FAIRING

Part Number : D34846
Drawing Number : D3484 REV D
Project Number : N/A
Drawing Revision : D
Material : *NA*
Due Date : 9/14/2007

Qty: *11* Um: Eac

Written By : *[Signature]*
Checked & Approved By : *[Signature]*
Comment : Est Rev: A New Issue 06-04-11 JLM

Additional Product

Job Number:



Seq. #: Machine Or Operation:

Description :

1.0 M6061T6S050

6061-T6 .050 Sheet



Comment: Qty.: 0.2904 sf(s)/Unit Total: 2.9043 sf(s)
6061-T6 .050 Sheet
(M6061T6S050)
Batch: *1117347*

2.0 WATER JET

FLOW WATER JET



SAD 07/09/08

Comment: FLOW WATER JET
Cut as per Dwg D3484

Dwg D
Ing R

SAD 07/09/08 1P

3.0 QC2

INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

4.0 QC8

SECOND CHECK



SAD 07/09/08 1P

Comment: SECOND CHECK

5.0 SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



center 07/09/08 (11)

Comment: SMALL & MEDIUM FAB RESOURCE 1

1-Deburr

SAD 07/09/13 (11)

FF 07-02-03

2-Roll as per Dwg D3484

07/11/29 XII

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: TAIL LIGHT FAIRING

Job Number: 34461

Part Number: D34846

Job Number:



Seq. #:	Machine Or Operation:	Description :
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6.0

QC5

INSPECT WORK TO CURRENT STEP



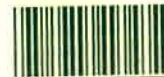
Comment: INSPECT WORK TO CURRENT STEP

PD 07/12/03 (10)

7.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: WS

PD 07-12-04 (2)

8.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

PD 07/12/07 (2)

Job Completion



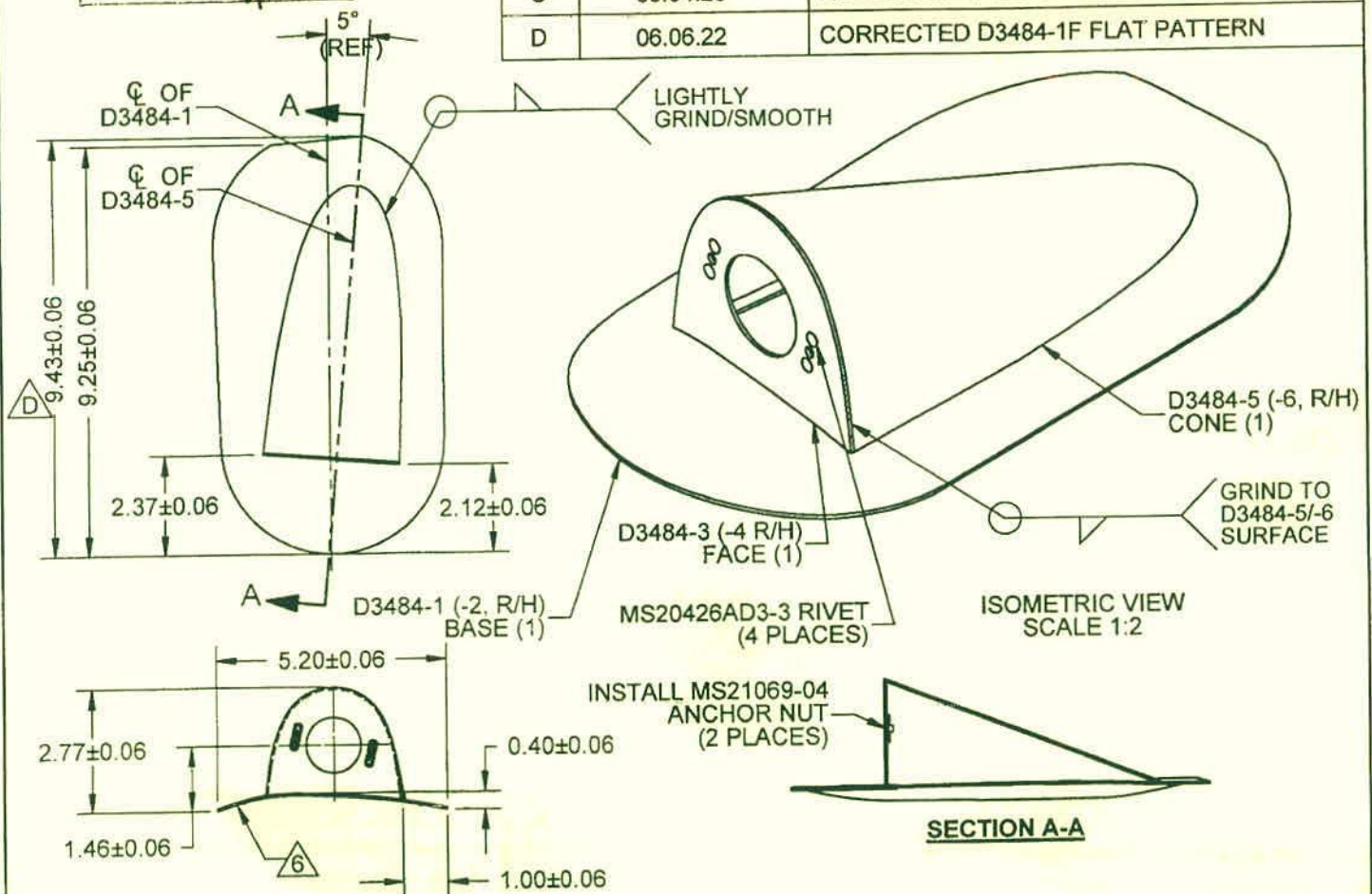
WS 07/12/07

DART

DESIGN	DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED	APPROVED	DRAWING NO. D3484	REV. D SHEET 1 OF 4
DATE	06.06.22	TITLE TAIL LIGHT FAIRING	SCALE 1:4
A	05.11.29	NEW ISSUE	
B	06.02.21	RE-DESIGN	
C	06.04.20	RE-DESIGN OF D3484-3F/-5F	
D	06.06.22	CORRECTED D3484-1F FLAT PATTERN	

RELEASED

06.08.17

**D3484-041 TAIL LIGHT FAIRING, L/H (SHOWN), R/H (OPPOSITE)****NOTES:**

- 1) WELD PER DART QSI 004
- 2) FINISH: ACID ETCH AND ALODINE PER DART QSI 005 4.1
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP EDGES 0.010 TO 0.020
- 6) IDENTIFY ON INSIDE SURFACE AS INDICATED WITH WHITE LABEL: "TCCA-PDA, DART AEROSPACE LTD., P/N D412-750-141/-142 B/N BXXXXX, FOR PRODUCT ELIGIBILITY SEE PDA06-13"

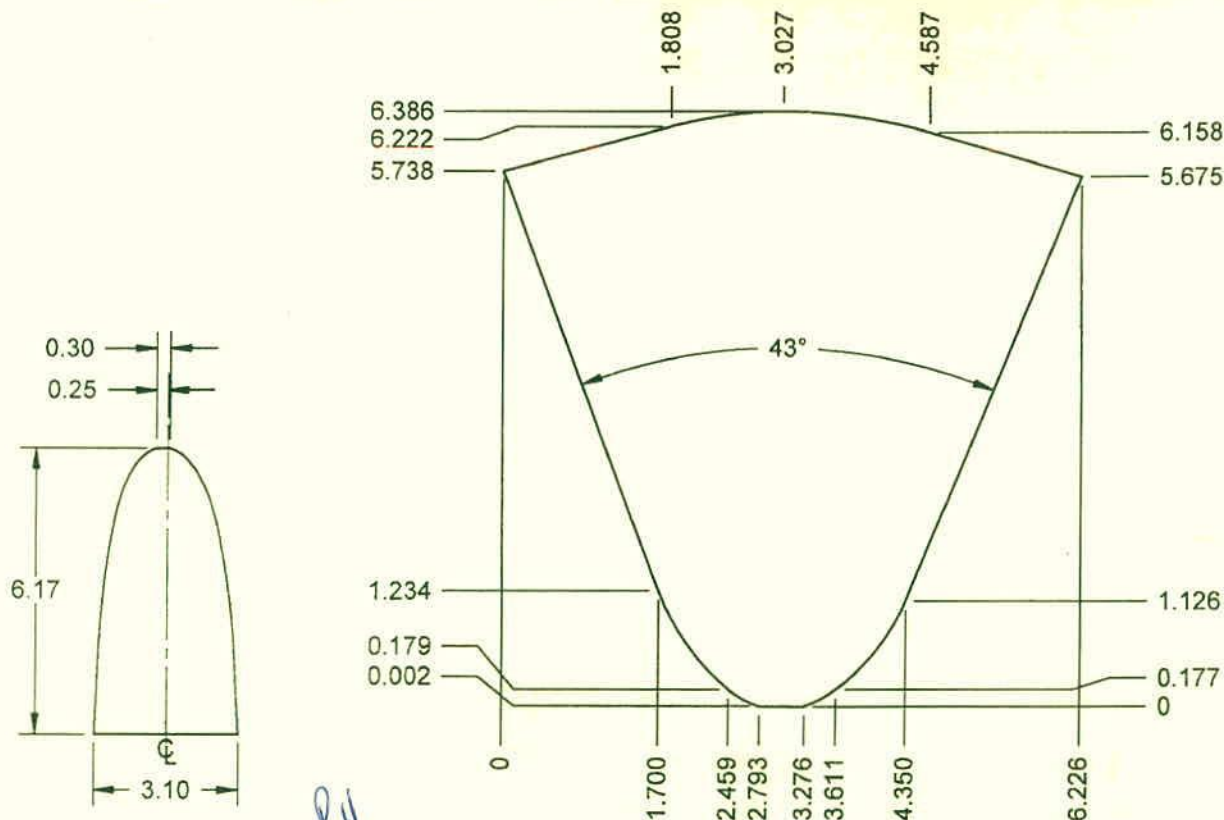
QTY -041	QTY -042	P/N	DESCRIPTION
X		D3484-041	TAIL LIGHT FAIRING ASSEMBLY (L/H)
	X	D3484-042	TAIL LIGHT FAIRING ASSEMBLY (R/H)
1		D3484-1	BASE (L/H) SHOP COPY
	1	D3484-2	BASE (R/H) RETURN TO
1		D3484-3	FACE (L/H) ENGINEERING
	1	D3484-4	FACE (R/H) UNCONTROLLED COPY
1		D3484-5	CONE (L/H) SUBJECT TO AMENDMENT
	1	D3484-6	CONE (R/H) WITHOUT NOTICE
4	4	MS20426AD3-3	RIVET WORK ORDER
2	2	MS21069-04	ANCHOR NUT NO. 34461

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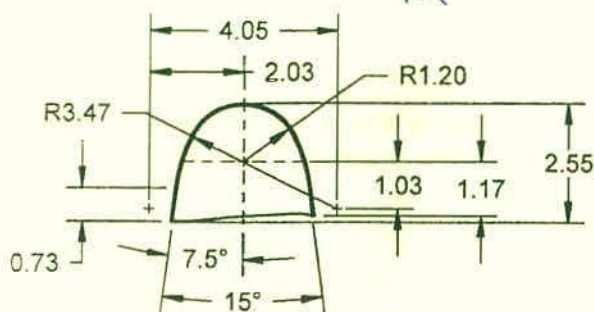
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DESIGN <i>[Signature]</i>	DRAWN BY <i>[Signature]</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3484	REV. D SHEET 4 OF 4
DATE 06.06.22		TITLE TAIL LIGHT FAIRING	SCALE 1:4



D3484-5F CONE FLAT PATTERN



D3484-5 L/H CONE BENDING DETAIL (-6 R/H, OPPOSITE)
(MAKE FROM D3484-5F)

NOTES:

- 1) MATERIAL: 6061-T6 (OR 6061-T62) ALUMINUM SHEET (0.050 THICK) PER AMS-QQ-A-250/11 OR AMS 4025 OR AMS 4027 (REF. DART SPEC. M6061T6S.050)
- 2) FINISH: NONE
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.010

RELEASED

06.08.17 *[Signature]*

SHOP COPY
RETURN TO
ENGINEERING

UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE

WORK ORDER

NO. *34461*

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